

Work Order ID 127450

127450

December-17-14 1:26:13 PM

Page 1

Item ID: D3782-044 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Front Outboard Leg Assembly, RH
Start Date: 12/17/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/17/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MCS Date: 14-12-22 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3782	Rev B								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1-assemble as per dwg D3782								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

FEB 05 2015

FEB 05 2015

DAS
38
9-89

FEB 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127450

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Page 2

December-17-14 1:26:13 PM

Item ID: D3782-044 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Front Outboard Leg Assembly, RH
 Start Date: 12/17/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>SAS3</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

62-6
90
SAC

FEB 05 2015

MLD

1502-06

MS-2-5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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December-17-14 1:26:13 PM

Work Order ID: 127450

127450

Parent Item: D3782-044

D3782-044

Parent Item Name: Front Outboard Leg Assembly, RH

Start Date: 12/17/14**Required Date:** 12/17/14**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C
10.02.22 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3768-4		Manufactured	No			110	Each	16.0000	1	1			
D3768-4 Front Outboard Leg, RH													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST252		16							
				116879		16							
D3787-1		Manufactured	No			110	Each	29.0000	1	1			
D3787-1 Foot													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST254		29							
				104557		5							
				<u>123684</u>		24							
D3762-041		Manufactured	No			110	Each	1.0000	1	1			
D3762-041 Front Leg Fitting Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST251		1							
				123471		1							

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:26:13 PM

Page 2

Work Order ID: 127450

127450

Parent Item: D3782-044

D3782-044

Parent Item Name: Front Outboard Leg Assembly, RH

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

AN45-13A Purchased No

110 Each 11.0000 2 2

AN45-13A

EYE BOLT

FF

FEB 05 2015

Location

Loc Qty

Loc Code

GA 10

m126293 10

ST340 1

m130205 1

2

MS21042L5 Purchased No

110 Each 628.0000 2 2

MS21042L5

Nut

FF

FEB 05 2015

Location

Loc Qty

Loc Code

GA 131340 496

m127813 496

ST305 132

m130358 132

2

NAS1149D0563J Purchased No

110 Each 2,162.000 2 2

NAS1149D0563J

Washer

FF

FEB 05 2015

Location

Loc Qty

Loc Code

GA 130

m125807 130

ST260a 400

m130799 400

ST269 632

m128257 632

ST271 1000

m131026 1000

2

DQA: _____ Date: _____



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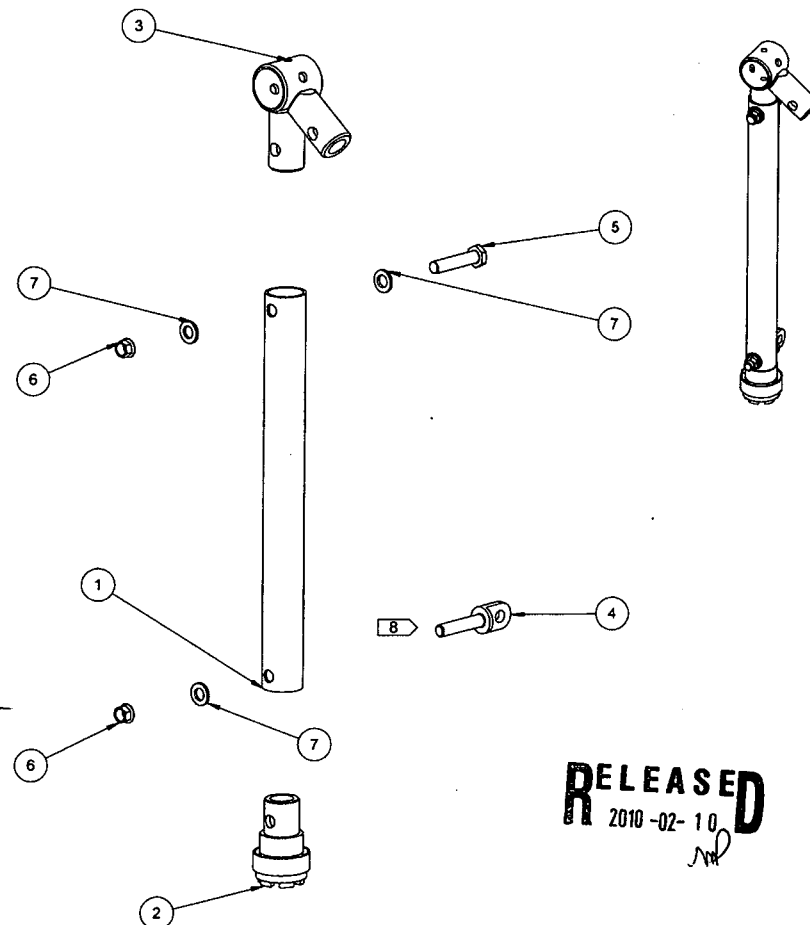
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

ITEM NO.	QTY. (-041)	PART NUMBER	DESCRIPTION
1	1	D3768-1	FRONT INBOARD LEG
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	1	AN45-13A	EYE BOLT
5	1	AN5-13A	BOLT
6	2	MS21042L5	NUT
7	3	NAS1149D0563J	WASHER (AN960JD516)

STG COPY
 REF TO SMO
 FROM EXR SO
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 W/OUT NOTICE
 WORK CENTER
 NO 127450-ML5
 14-12-22



RELEASED
 2010-02-10

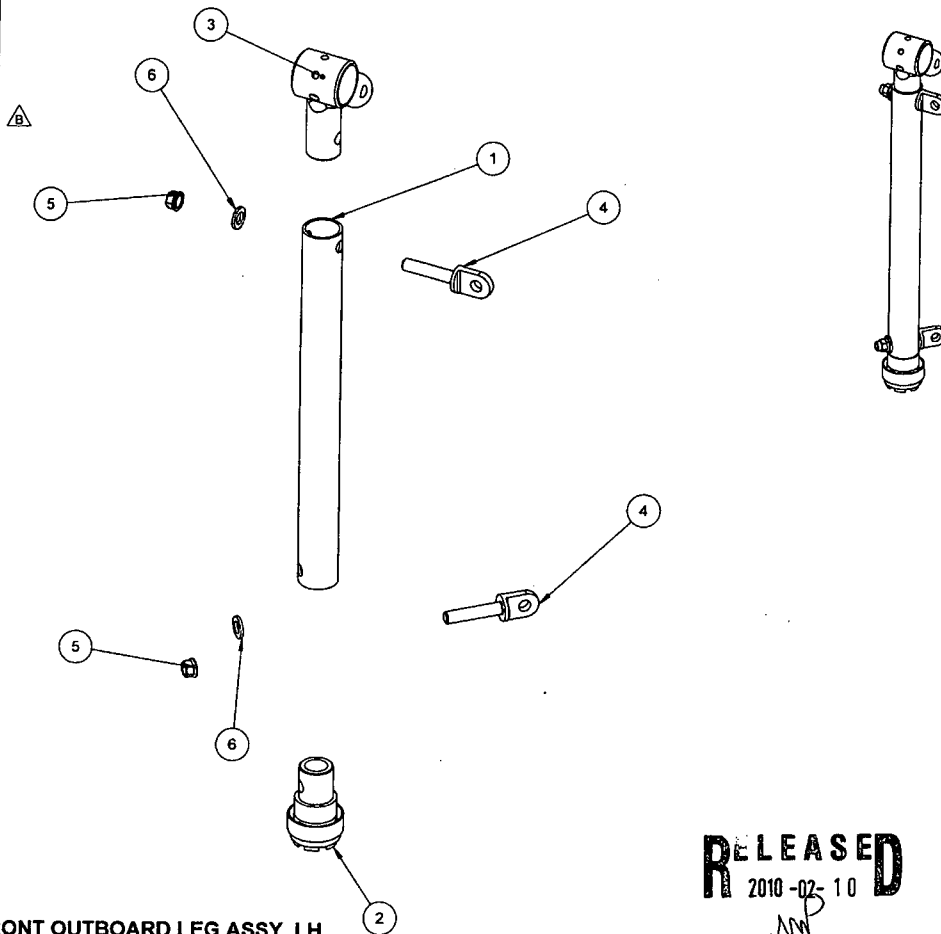
D3782-041 FRONT INBOARD LEG ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.42 lbs
 - 8) ITEM 4 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

B	REVISE P/N NAS1149D0568J TO NAS1149D0563J ALL SHEETS, ZN D7	HS	10.01.21
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.21		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3782	REV. B
TITLE LEG ASSEMBLY	SCALE NTS
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ITEM NO.	QTY. (-043)	PART NUMBER	DESCRIPTION
1	1	D3768-3	FRONT OUTBOARD LEG, LH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)



D3782-043 FRONT OUTBOARD LEG ASSY, LH

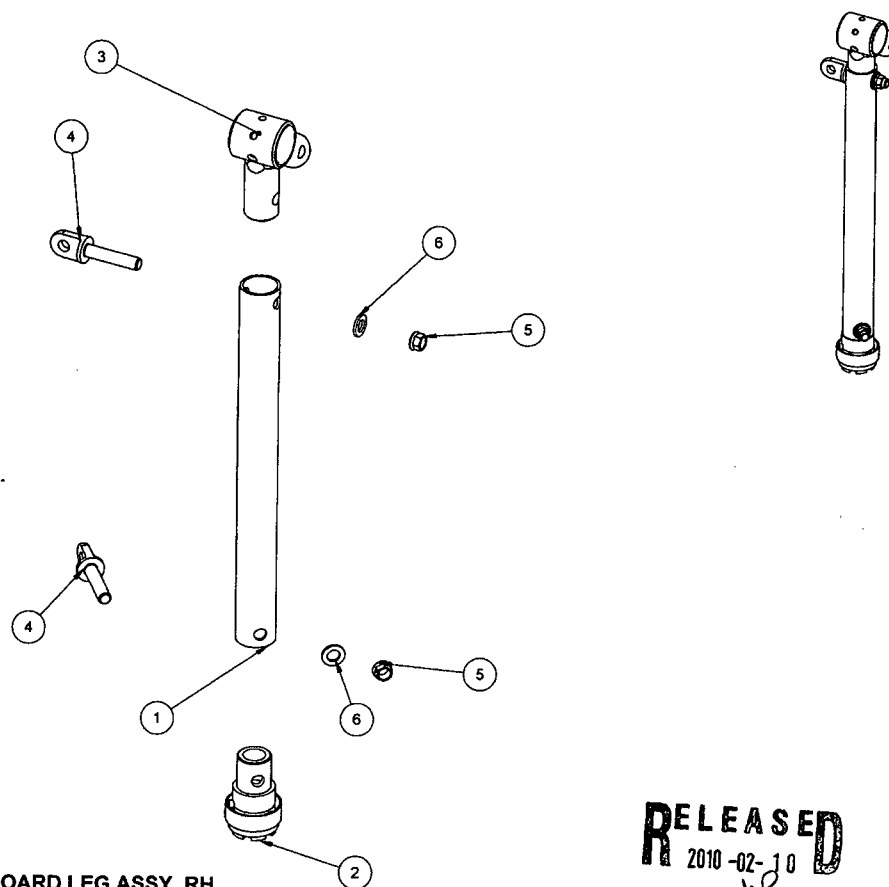
RELEASED
2010-02-10
NW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3782	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LEG ASSEMBLY	NTS
DATE	10.01.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM NO.	QTY. (-044)	PART NUMBER	DESCRIPTION
1	1	D3768-4	FRONT OUTBOARD LEG, RH
2	1	D3787-1	FOOT
3	1	D3782-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)



D3782-044 FRONT OUTBOARD LEG ASSY, RH

RELEASED
2010-02-10
NR

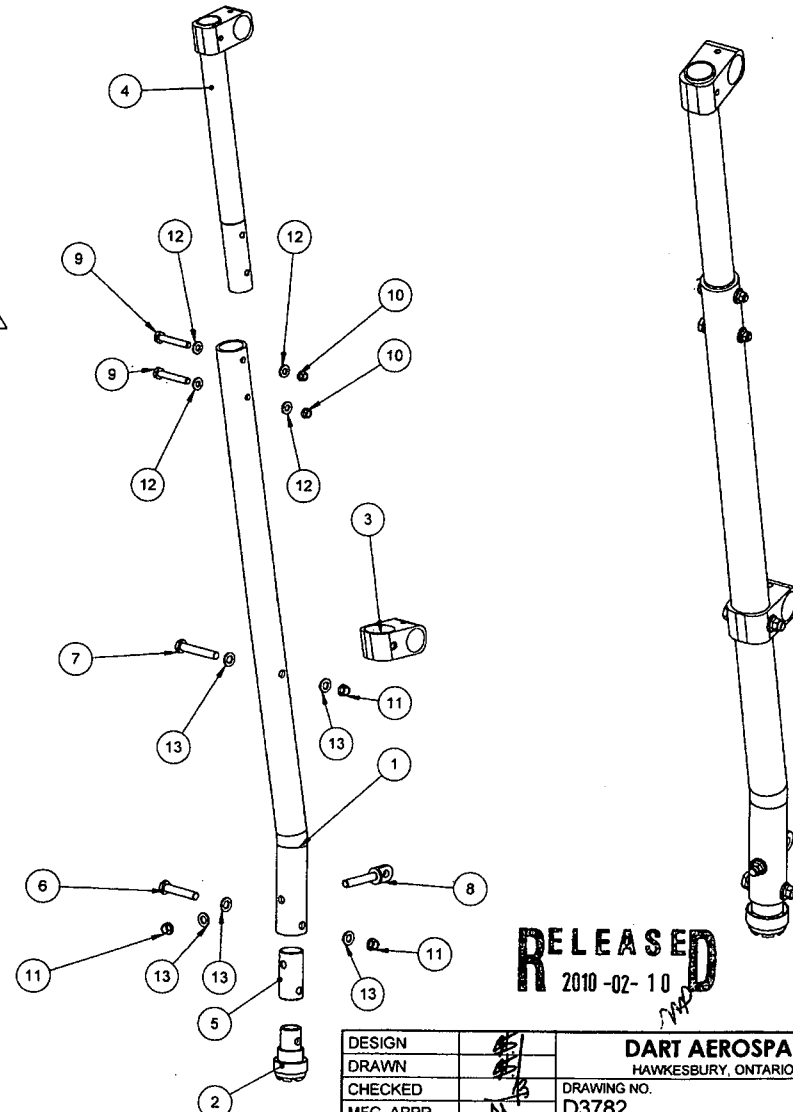
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3782	REV. B
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE LEG ASSEMBLY	SCALE
DE APPR.			NTS
DATE	10.01.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM NO.	QTY. (-045)	PART NUMBER	DESCRIPTION
1	1	D3772-1	BACK LEG
2	1	D3787-1	FOOT
3	1	D3764-1	BACK LEG FITTING
4	1	D3773-041	HEAD REST ADAPTER ASSY
5	1	D3786-1	SLEEVE
6	1	AN5-15A	BOLT
7	1	AN5-17A	BOLT
8	1	AN45-15A	EYE BOLT
9	2	AN4-15A	BOLT
10	2	MS21042L4	NUT
11	3	MS21042L5	NUT
12	4	NAS1149D0463J	WASHER (AN960JD416)
13	5	NAS1149D0563J	WASHER (AN960JD516)

D3782-045 BACK LEG ASSY



RELEASED
2010-02-10

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.71 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3782	REV. B
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE LEG ASSEMBLY	SCALE
DE APPR.			NTS
DATE	10.01.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	